

5/13

DART AEROSPACE LTD	Work Order:	22542
Description: Spacer	Part Number:	D2808
Dwg: D2808 rev.A1	Qty:	100

05.02.23 *up* 05.02.23 *up*

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Issue W/O	<i>PH</i>	05.02.24	100
2	COBRA	Machine as per Folio FA205 Material: 6061-T6 (QQ-A-250/11) or (QQ-A-225/8) rod .500"Ø Batch: <i>M15211</i>	<i>PH</i>	05.03.03	100
3	QC	Inspect level 2	<i>PH</i>	05.03.03	100
4	QC	Inspect Level 8	<i>PH</i>	05.03.03	100
5	CNC CELL	Tumble & deburr all sharp edges	<i>PH</i>	05.03.03	100
6	QC	Inspect Level 5	<i>PH</i>	05.03.03	100
7	FINISHING	Chemical conversion coat per QSI 005 4.1	<i>MM</i>	05.03.09	100
8	FINISHING	Powder coat <i>white</i> per QSI 005 4.3	<i>MM</i>	05.03.15	100
9	QC	Inspect Level 3	<i>U</i>	05.03.16	100
10	STORES	Identify and stock	<i>U</i>	05.03.16	100
11	EXPEDITING	Close W/O Inspect level 21 Cost / part: <i>1.49</i> <i>545</i> 05/03/17 <i>100</i>	<i>PH</i>	05.03.18	100

Rev	Date	Change	Revised By	Approved
A	00.11.06	New Issue	EC	
B	00.11.14	Revised inspection level 2 to 6	EC	
C	01.04.26	Re format	EC	
D	02.03.07	Now turned in house	NG	<i>SP02-03-11</i>

RELEASED

02/03/11 *PH*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

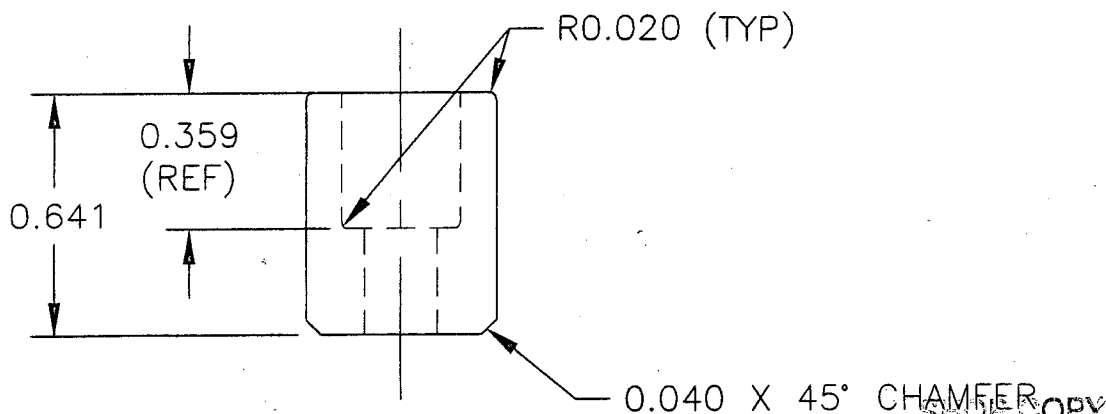
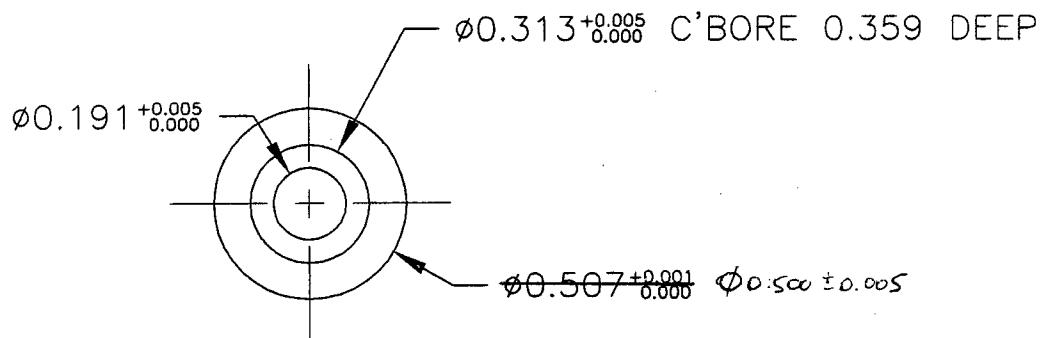
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



DESIGN <i>HA</i>	DRAWN BY <i>HA</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CP</i>	APPROVED <i>HA</i>	DRAWING NO. D2808	REV. A SHEET 1 OF 1
DATE 00.11.07		TITLE SPACER	SCALE 2:1
A	00.11.07	NEW ISSUE	
A1	<i>tip</i> 01.04.26	ADD POWDER COAT ; $\phi 0.500$ WAS $\phi 0.507$	

RELEASED
C 4.13 *HA*



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ENGINEERING

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SUBJECT TO AGREEMENT
WITHOUT NOTICE

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
BREAK ALL UNMARKED SHARP CORNERS 0.010 TO 0.020
MATERIAL: 6061-T6 (QQ-A-250/11) OR (QQ-A-225/8)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

POWDER COAT WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6) OR BLACK SANDTEX (4.3.5.7)
OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

WORK ORDER

NO. 22542

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Feb 23, 2005
02:12 pm

Work Order No : 0022542
Project Name : D2808
Project For : WK513
Work Order Type : Main
Main WO Number :
House Part Number : D2808
Description : Spacer
Manufactured : Yes
Amount Req'd : 80
Amount Done : 0
Start Date : 02-23-05
Est Finish Date : 03-15-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

DART AEROSPACE LTD		Work Order:	22542
Description: SPACER		Part Number:	D2808
Inspection Dwg: D2808 Rev: A1		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

X

[illegible]

Measured by:	Audited by:	Prototype Approval:
Date:	Date:	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	